Qty:

2 Um:

Each

¿Date

Friday, 25/07/2008 4:20:58 PM

User:

## **Process Sheet**

**Drawing Name** 

Part Number

Material

**Due Date** 

**Drawing Number** 

**Project Number** 

**Drawing Revision** 

: BRACKET

: D21972

: N/A

: C

: D2197 REV C

: 20/08/2008

Customer

: CU-DAR001 Dart Helicopters Services

Type

S.O. No. :

: 40767

Julie Lecocq

Job Number **Estimate Number** 

: 13516

P.O. Number

: 25/07/2008 This Issue : NC

Prsht Rev. First Issue : 11

**Previous Run** 

Written By

Checked & Approved By

Comment

: Est Rev:A

: SMALL /MED FAB

08-07-24 new issue ec verified by:dd

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

304/316 Sheet .063

1.0 M304S16GA

Comment: Qty.;

0.2915 sf(s) 0.1457 sf(s)/Unit Total:

304 SS Sheet 0.063" thick

batch: 108734

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2196 Dwg Rev:\_

Prog Rev:

B 8-8-31

2-Deburr if necessary

3.0

QC2

1-8-8-21

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE

Comment: NC BRAKE

Bend as per dwg D2196

## **Dart Aerospace Ltd**

W/O:			WC	RK ORDER CHAN	GES						
DATE STEP		PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Cate	gory:	NCR	: Yes	No DQ	<b>\</b> :	Date:		
						QA: N/	C Close	d:	_ Date: _		
NCR:			WORK ORDI	ER NON-CONFORM	IANCE	(NCR	)				
DATE	STEP	Description of NC	Corrective Action Section B Verification				Approval	Approval			
DAIL	JOIL!	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	& Section	Section C	on C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

Friday, 25/07/2008 4:20:58 PM Date: > User: Julie Lecocq **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Part Number: D21972

Job Number: 40767 Job Number:

Seq. #: **Machine Or Operation:**  Description:

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Identify wiith\_Dart part # using a fine point permahent marker and Stock

Location:

FINAL INSPECTION/W/O RELEASE

QC21 8.0

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08/08/26

# **Dart Aerospace Ltd**

W/O:		WORK ORDER C	HANGES			+-	
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						1	
						İ	
Part No		DAD # . Fault Catagonia	NOD: Vaa			D-4	

Part No:	_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
		•	QA: N/C C	losed:	Date:

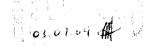
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Verification		Ι					
DATE	STEP	Section A	Initial   Action Description   Sign & Date		Section C	Approval Chief Eng	Approval QC Inspecto				
							;				
							ļ				
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							:				
							j				

NOTE: Date & initial all entries





DESIG	*#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	(ED	APPROVED /	DRAWING NO. REV.	С
_		#	D2197 SHEET 1 OF	1
DATE			TITLE SCAI	LE
03.0	5.28		BRACKET . 1	:2
В		93.09.23	REDESIGN	
С		03.05.28	REDRAW; D2197-3 NOW 0.5" THICK	



1.49 R0.50 (TYP ALL CORNERS) (D2197-3)-4.000Ø0.257 -- 3.625 0 -3.0003.200 -- 2.688 00.203 (TYP 5 PLACES) -1.7502197-1/-2-0.813 0.375 0.500 Ø0.128 (TYP 4 PLACES) 0.300 - 0.000 (TYP) 2.819 2.390 2.090

#### D2197-1/-2

1) MATERIAL: AISI 304/316 S.S. 0.064" THICK (M304S16GA)

D2197-1/-2/-3

FLAT PATTERN

D2197 - 32) MATERIAL: 5052H32 (QQ-A-250/8) 0.500" THICK OR 4x0.125 THICK 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

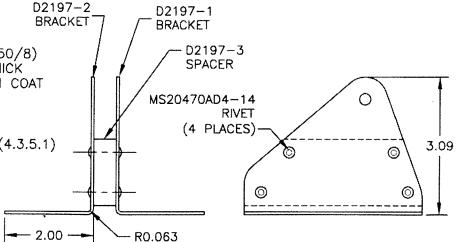
#### D2197 BRACKET (ASSEMBLY):

4) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

### **GENERAL NOTES:**

- 5) ALL DIMENSIONS ARE IN **INCHES**
- 6) TOLERANCES ARE PER DART QSI 018 \UNLESS OTHERWISE NOTED

7) BREAK ALL SHARP EDGES 0.005 TO 0.015



D2197 BRACKET (ASSEMBLY)

SHOP COPY RETURN TO **ENGINEERING** 

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DART AEROSPACE LTD	Work Order:	40767
Description: RRACKET	Part Number:	D3141-5
Inspection Dwg:\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
861. D	100200,4	.136	X			
EOG. D	4.005001	1204	×			
CSC. V	+ 006001	1954	*			
,375	4- 010	,375	A			
	VIO. 1	1.760	≫			
<del>2.390</del>	+/010	2.345	<b>X</b>			
086,8	t/ . 010	3,784	×			
4,480	4010	4.480	×			
4.980	t00	4,980	<b>X</b>			
.375	- 010	375	×			
813	4 .010	, 813	<b>y</b>			
<u> </u>	4 .010	1.753	×			
2.688	4 .00	282.6	ملا			
3.625	010.	3,625	*			
4.000	(10, -17	4.004	*			
50,	4/010	,061	<b>x</b>			
	`					
			`			

Measured by:	IB.	Audited by:	6,,		Prototype Approval:	N	
Date:	16-8-8	Date:	08/08/2	2	Date:		4

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

